Work Order ID 78817

January-16-12 11:22:17 AM

78817

Item ID: D206-667-201TRN **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Crosstube Turning Detail

Start Date: 16/01/2012 **Start Qty:** 1.00 *1*

Required Date: 30/01/2012 **Req'd Qty:** 1.00 *1*

Cust Item ID:

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** M C J **Date:** 12/01/16 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D206-667-241	Rev C								
100		0.00							
100	MORI SEIKI CNC LATHE LARGE								
Mori Seiki	**Memo**	0.00							
Mori Seiki CNC Lathe Large	1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA084								
	2-Turn first side as per Folio FA084								
	3-Blend transition lines only, **do not sand whole tube**:								
	FOLIO REV: AA								
	DWG REV: C								
	*Use mill bastard file, brush file repeatedly with file card.								
	*Do not use sandpaper coarser than 320 grit.								
110	QC1- Inspect dimensions to dimension sheet	0.00							
110									
QC	**Memo**	0.00							
Quality Control									

KC/MML 12/03/28

KC/MML 12/03/28

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 78817

January-16-12 11:22:17 AM

78817

Item ID: D206-667-201TRN **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Crosstube Turning Detail

Start Date: 16/01/2012 **Start Qty:** 1.00 *1*

Required Date: 30/01/2012 **Req'd Qty:** 1.00 *1*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
120	MORI SEIKI CNC LATHE LARGE								
Mori Seiki	**Memo**	0.00							
Mori Seiki CNC Lathe Large	1-Turn second side as per Folio FA084 2-File down transition lines smooth. 3-Blend transition lines only, **do not sand whole tube**: *Use mill bastard file, brush file repeatedly with file card. FOLIO REV:_____ DWG REV:_____ *Do not use sandpaper coarser than 320 grit.								
130	QC1- Inspect dimensions to dimension sheet	0.00							
130									
QC	**Memo**	0.00							
Quality Control									

K Jamal 12/03/28

K Jamal 12/03/28

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Item ID: D206-667-201TRN **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Crosstube Turning Detail
Start Date: 16/01/2012 **Start Qty:** 1.00 *1*
Required Date: 30/01/2012 **Req'd Qty:** 1.00 *1*
Reference:
Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC8- Inspect parts - second check	0.00				12-3-29			
140									
QC	**Memo**	0.00							
Quality Control									
145		0.00							
145									
Crosstubes	**Memo**	0.00				12-3-29			
Crosstubes	GRIND ONLY TRANSITION LINES SMOOTH LONGITUDE WAY.								
150	Crosstubes Chemical Conversion	0.00				12-3-29			
150									
HandFXtube	**Memo**	0.00							
Hand Finishing Crosstubes									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 78817

January-16-12 11:22:17 AM

78817

Item ID: D206-667-201TRN **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Crosstube Turning Detail

Start Date: 16/01/2012 **Start Qty:** 1.00 *1*

Required Date: 30/01/2012 **Req'd Qty:** 1.00 *1*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	**Memo**	0.00 S 12/03/30							
Quality Control									
170		0.00				1 6			
170	Packaging								
Packaging	**Memo**	0.00							
Packaging	Identify and Stock in kanban rackLocation: L/G								
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	**Memo**	0.00							
Quality Control									

Ke/mmL 12/03/30

12/3/30

12/03/30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

January-16-12 11:22:20 AM

Work Order ID: 78817 *78817*

Parent Item: D206-667-201TRN *D206-667-201TRN*

Parent Item Name: Crosstube Turning Detail

Start Date: 16/01/2012 **Required Date:** 30/01/2012

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP Rev:A 08-03-06 new issue DD verified by:ec
IPP Rev B 08.04.02 Removed polish EC verified by:DD
IPP Rev:C 08-12-23 revc as per dwg DD verified by JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6003-102		Manufactured	No			110	Each	59.0000	1	1			
D6003-102									**				
Crosstube, 206													

Location	Loc Qty	Loc Code
LG	59	
29116	12	
38335	47	

1 Mark - 12/03/27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	78817
Description: Crosstube Assembly	Part Number:	D206-667-241
Inspection Dwg: D206-667-241 **Rev:** C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	30° x 0.500	+/-0.010	20° x 5.00	✓			
	0.250	+/-0.010	.250	✓		VERN	
	2.240	+0.005/-0.000	2.244	✓		↓	
	4.438	+/-0.030	4.438	✓		↓	
	1.780	+0.005/-0.000	1.784	✓		↓	
	R0.063	+/-0.010	.063	✓		RADIUS GAGE	
	1.851	+0.005/-0.000	1.856	✓		VERN	
	1.928	+0.005/-0.000	1.930	✓		↓	
	2.005	+0.005/-0.000	2.005	✓		↓	
	2.082	+0.005/-0.000	2.083	✓		↓	
	2.159	+0.005/-0.000	2.162	✓		↓	
	2.190	+0.005/-0.000	2.192	✓		↓	
SIDE B	30° x 0.500	+/-0.010	30° x .500	✓			
	0.250	+/-0.010	.250	✓		VERN	
	2.240	+0.005/-0.000	2.244	✓		↓	
	4.438	+/-0.030	4.438	✓		↓	
	1.780	+0.005/-0.000	1.785	✓		↓	
	R0.063	+/-0.010	.063	✓		RADIUS GAGE	
	1.851	+0.005/-0.000	1.856	✓		VERN	
	1.928	+0.005/-0.000	1.928	✓		↓	
	2.005	+0.005/-0.000	2.007	✓		↓	
	2.082	+0.005/-0.000	2.082	✓		↓	
	2.159	+0.005/-0.000	2.161	✓		↓	
	2.190	+0.005/-0.000	2.192	✓		↓	
	100.60	+/-0.020	100.60	✓		tape	

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	12/03/27	Date:	12-3-25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.10.16	New Issue (P/O D206-667-201)	KJ/JLM	
B	09.05.20	Dwg Rev updated	KJ	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

ULTRA SONIC MEASURMENTS

Side	LOCATION on tube	R1	R2	R3	R4
A		.262	.368		
		.259	.342		
		.254	.339		
		.254	.353		
B		.270	.366		
		.262	.358		
		.237	.325		
		.261	.352		

Part number	7881
Batch number	26.267-201
Measured By	Manil / Ko

Item	Qty -241	Part Number	Description
1	X	D206-667-241	CROSSTUBE ASSEMBLY (206B HIGH AFT)
2	1	D6003-102	CROSSTUBE
3	2	D2891-1	SUPPORT
4	4	D3595-063-395	RUBBER CUSHION
5	4	MS21920-20	CLAMP (OR MS21920-21)
6	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

1) MATERIAL: MANUFACTURED FROM D6003-102
   FINISHED LENGTH = 100.60±0.020
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
   PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
   PAINT OUTSIDE PER DART QSI 005 4.2
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
4) UNITS: INCHES UNLESS OTHERWISE NOTED.
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-241" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
7) WEIGHT: 22.5 lbs
8) PART IS SYMMETRIC ABOUT CENTERLINE.
9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
10) BEND PROGRESSIVELY WITH A MINIMUM OF 12 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS MECHANISMS ARE LOCATED ON CROSSTUBE CLAMPS.
14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SUBMITTED FOR UNCONTROLLED COPY
SUBJECT TO CHANGE
WORK ORDER
NO 78817 M.C.J
12/01/16

UNDER REVIEW
OK 11.08.23

RELEASED
08/11/12

DEO ATTACHED

REV.	DESCRIPTION	BY	DATE
C	REFORMAT/REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-395 WAS D2856-400-694 (ZN D6-2 & A5-2); REMOVED REF. & ADD TOLERANCES (ZN C5-3, C4-3, D3-3); RELOCATED FLAG #6 (ZN A7-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
B	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	PH	05.02.04
A	NEW ISSUE	CP	00.11.17

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D206-667-241	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE ASS'Y (206B HIGH AFT)	NTS
DATE	08.11.06		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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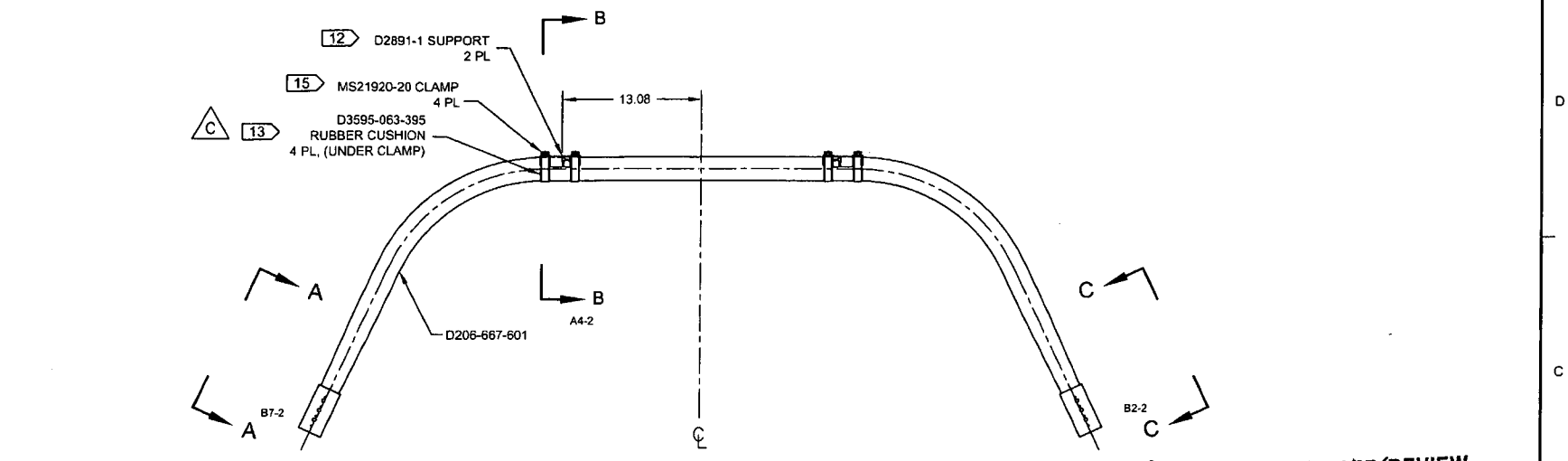
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

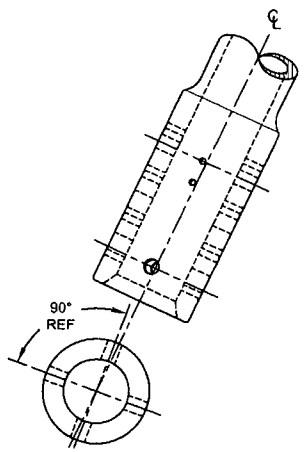
78817



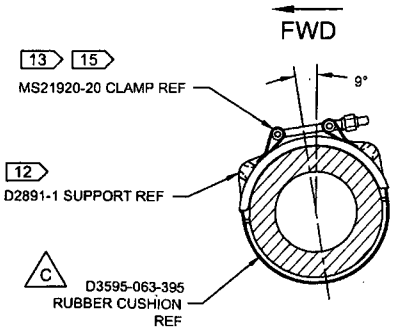
C D206-667-241
ASSEMBLY DETAIL
(VIEW LOOKING FWD)

UNDER REVIEW
11.05.13 OK 11.08.13

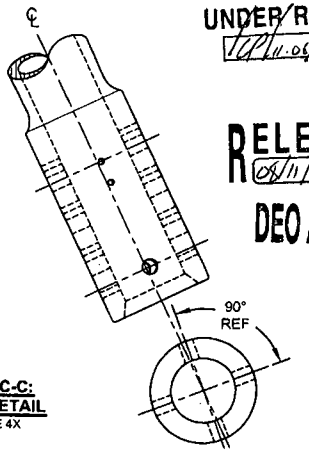
RELEASED
05/11/12
DEO ATTACHED



C6-2 **VIEW A-A: CUFF DETAIL**
SCALE 4X



D5-2 **SECTION B-B**
SCALE 5X



C3-2 **VIEW C-C: CUFF DETAIL**
SCALE 4X

DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED		DRAWING NO. D206-667-241 REV. C SHEET 2 OF 4
MFG. APPR.		
APPROVED		TITLE CROSSTUBE ASS'Y (206B HIGH AFT) SCALE NTS
DE APPR.		
DATE 08.11.06		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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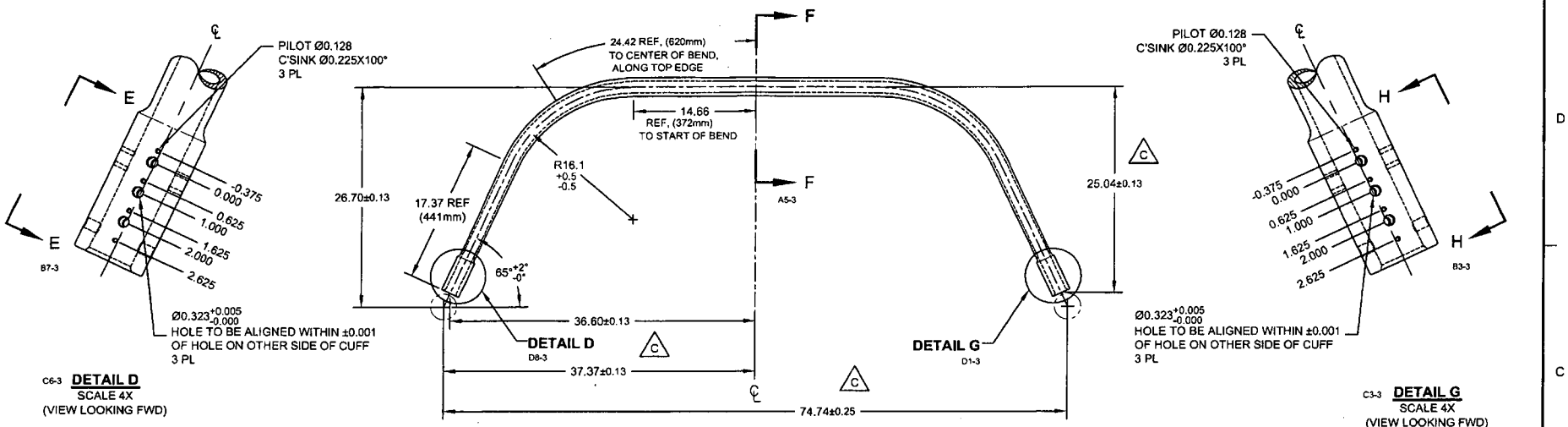
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

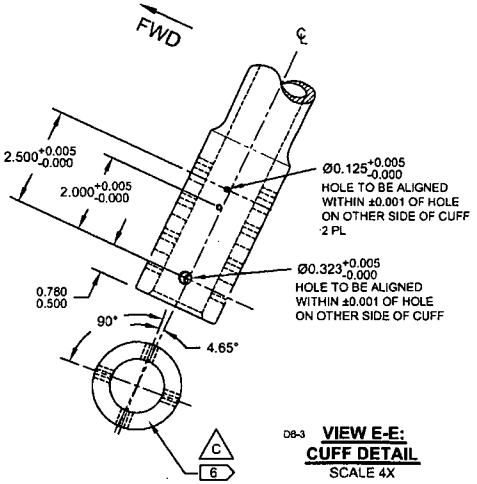
79817



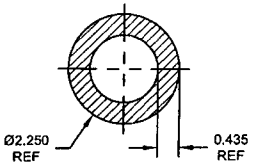
C6-3 **DETAIL D**
SCALE 4X
(VIEW LOOKING FWD)

C3-3 **DETAIL G**
SCALE 4X
(VIEW LOOKING FWD)

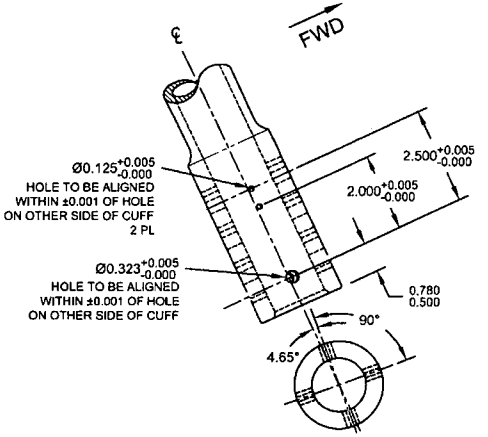
C 10 **D206-667-601**
BENDING AND DRILLING DETAIL
(VIEW LOOKING FWD)



D8-3 **VIEW E-E:**
CUFF DETAIL
SCALE 4X



D4-3 **SECTION F-F**
SCALE 5X



D1-3 **VIEW H-H:**
CUFF DETAIL
SCALE 4X

UNDER REVIEW
11.06/12
OK 11.08.12

RELEASED
06/11/12
DEO ATTACHED

DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED		DRAWING NO. D206-667-241 — REV. C — SHEET 3 OF 4
MFG. APPR.		
APPROVED		TITLE: CROSSTUBE ASS'Y (206B HIGH AFT) — SCALE: NTS
DE APPR.		
DATE	08.11.06	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

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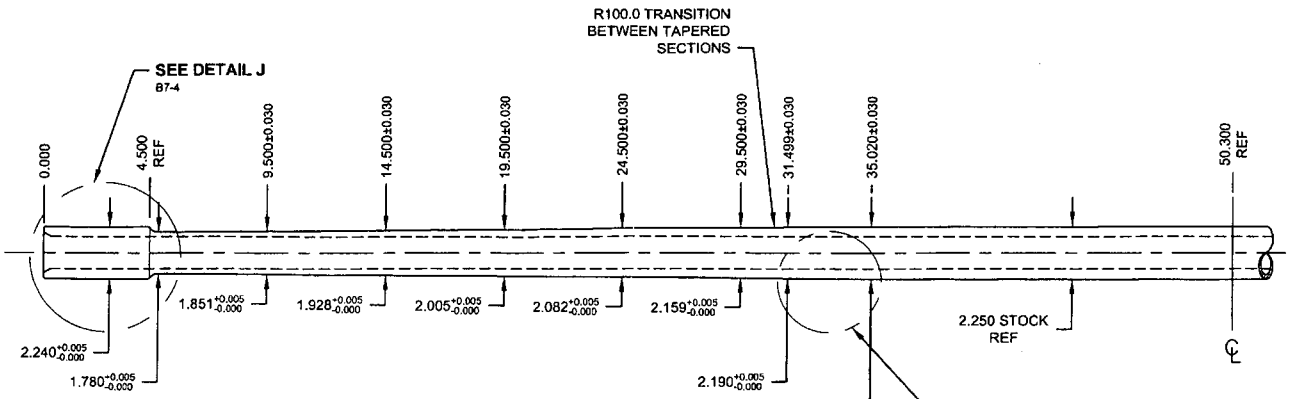
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

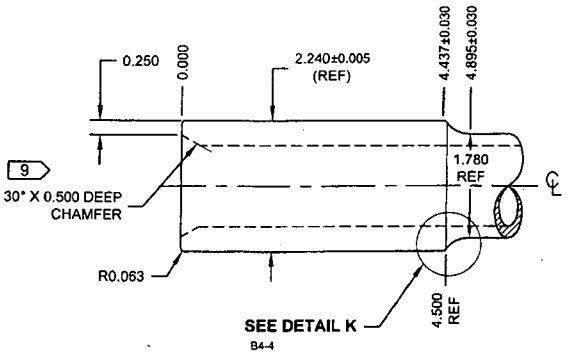
NOTE: Date & initial all entries

78817

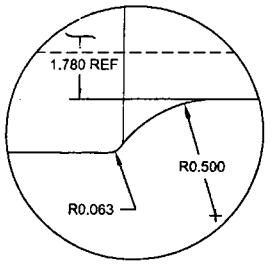


UNDER REVIEW
11.06.17 GK
11.08.23

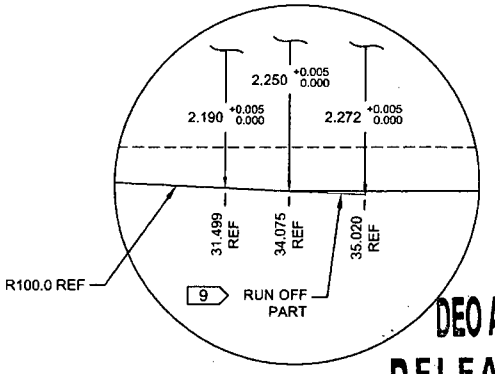
C TURNING DETAIL



D7-4 **DETAIL J: CROSSTUBE CUFF**
NOT TO SCALE



A6-4 **DETAIL K: CUFF TRANSITION**
NOT TO SCALE



C4-4 **DETAIL L: TAPER RUN-OFF**
NOT TO SCALE

DEO ATTACHED
RELEASED
06/11/12

DESIGN		**DART AEROSPACE LTD**	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D206-667-241	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE ASS'Y (206B HIGH AFT)	NTS
DATE	08.11.06	COPYRIGHT © 2000 BY DART AEROSPACE LTD	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

78817

DRAWING NO.	TITLE	REV. C	DART AEROSPACE LTD	D.E.O. NO.	SHEET NO.	SCALE
D206-667-241	CROSSTUBE ASS'Y (206B HIGH AFT)		ENGINEERING ORDER	D206-667-241-C-1	SHEET 1 OF 1	NTS

DRAWN	CHECKED	MFG. APPR.	APPROVED	DE APPR.
DATE 11.07.15	DATE 11.08.22	DATE 11.08.22	DATE 11/08/22	DATE 11.08.22

PURPOSE:
REPLACE MAGNOBOND WITH PROSEAL.

CHANGE:

IS:

Item	Qty -241	Part Number	Description
6	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

WAS:

6	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

NOTE 12 & 15, SHEET 1 IS AMENDED AS FOLLOWS:

IS:

12) TO INSTALL D2891-1 SUPPORT: ABRADE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.

15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. **PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.**

WAS:

12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.

15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

RELEASED
2011 -08- 23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries